

Work Order ID 111110

Thursday, January 09, 2014 11:29:44 AM

111110

Page 1

Item ID: PB67-43001-23

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lower Blade Support And Cover Assembly

Start Date: 1/8/2014 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: mf Date: 14-01-09 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-23	Rev C

100 Small Fab 0.00

100

Small Fab Memo 0.00

Small Fab Assemble as per dwg PB67-43001

① 14-02-14 PD

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC Memo 0.00

Quality Control

4 φ DA 19

120 Identify as per dwg & Stock Location: W1.03 0.00

120

Packaging Memo 0.00

Packaging

4 φ 14.02.14

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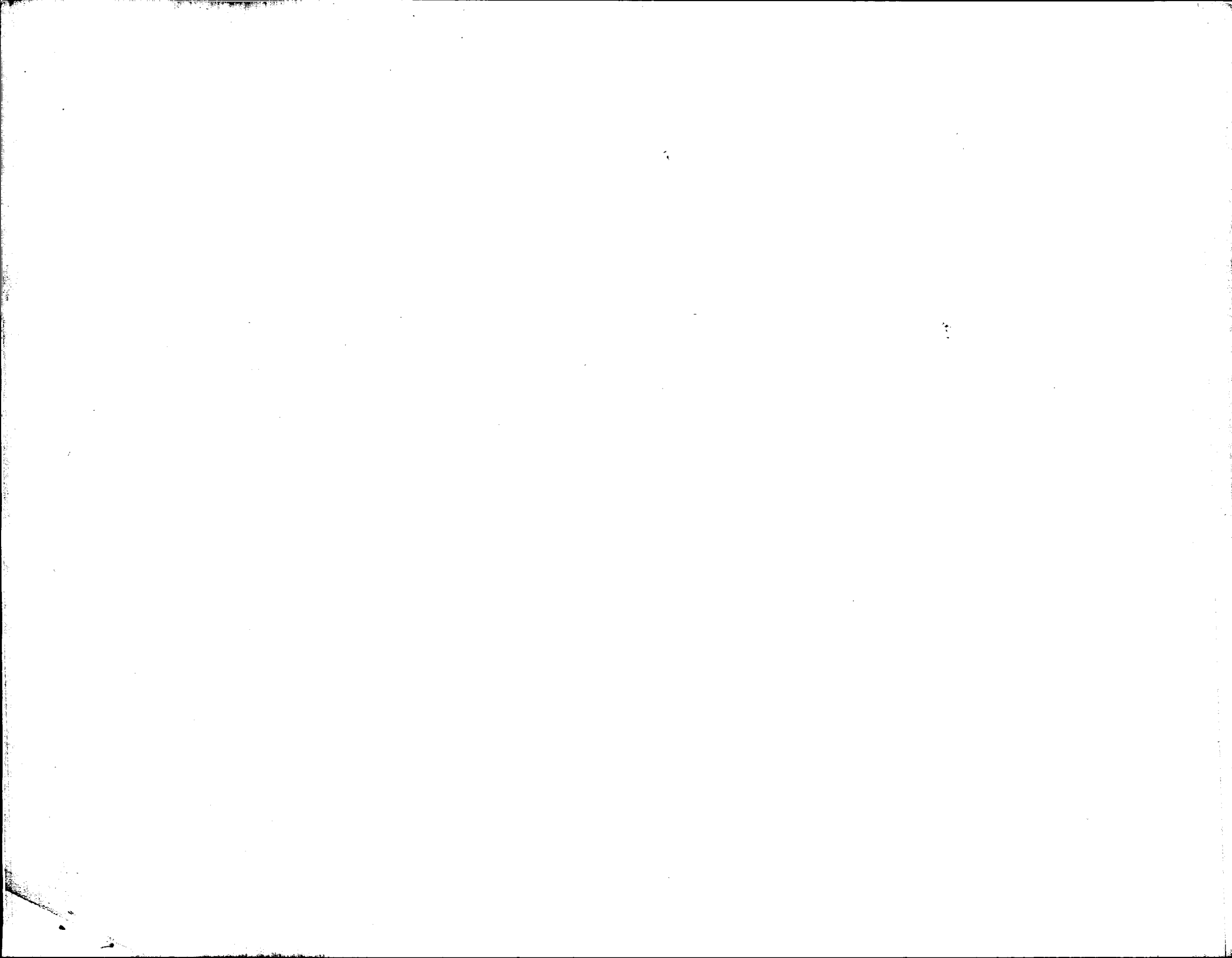
Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

14-02-14



Picklist Print

Thursday, January 09, 2014 11:29:44 AM

Page 1

Work Order ID: 111110

Parent Item: PB67-43001-23

Start Date: 1/8/2014

Required Date: 1/24/2014

Parent Item Name: Lower Blade Support And Cover Assembly

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec
dwg EC verified by:DD
IPP Rev B 10.09.28 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-10 SCREW		Purchased	No			100	Each	256.0000	8	16		③ 14-02-13 PD	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		100			M127993 -> 16				
				①20449		100			16				
				ST506		156							
				m126474		156							
NAS1149D0316J Washer		Purchased	No			100	Each	135.0000	8	16		③ 14-02-13 PD	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST294		135			M127993 -> 1632				
				123482		135							
NAS1149D0363J Washer		Purchased	No			100	Each	3,689.0000	12	24		③ 14-02-13 PD	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		154							
				124392		154							
				ST510a		3535							
				①126319		2335			24043				
				m127813		1200							
PB67-43001-181 Cover Plate		Manufactured	No			100	Each	9.0000	1	2		② 14-02-13 PD	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		9							
				⑤3336		1			1				
				⑨0912		2			2				
				⑨9991		6			1				

Picklist Print

Thursday, January 09, 2014 11:29:44 AM

Page 2

Work Order ID: 111110

Parent Item: PB67-43001-23

Start Date: 1/8/2014

Required Date: 1/24/2014

Parent Item Name: Lower Blade Support And Cover Assembly

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-79

Manufactured No

100

Each

1.0000

1

2

Lower Blade Support Assembly

Location

Loc Qty

Loc Code

Mezz2

1

106506

1

PB67-43001-83

Manufactured No

100

Each

16.0000

1

2

D-Pad Assembly, Short

Location

Loc Qty

Loc Code

Mezz2

16

100022

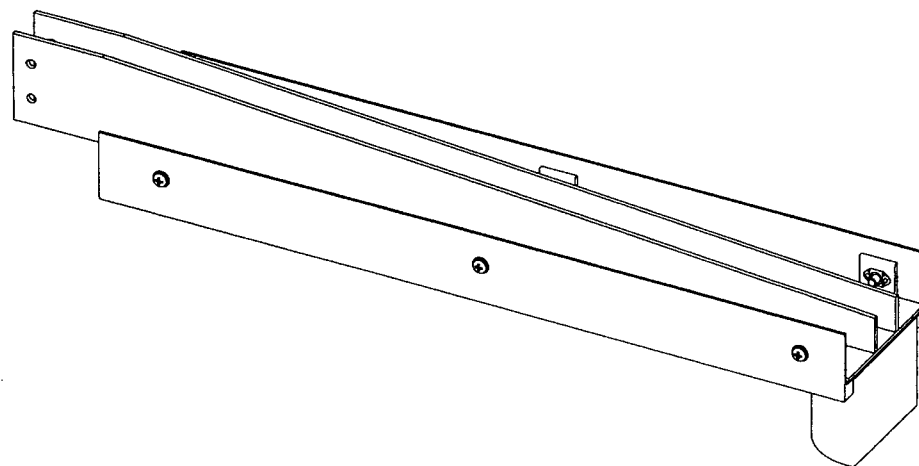
16

(4) 14-02-13 PD

B111B03 -> 4

(4) 14-02-13 PD

4



B67-43001-23 LOWER BLADE SUPPORT AND COVER ASSY

ITEM	QTY -23	P/N	DESCRIPTION
1	X	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
3	1	B67-43001-79	LOWER BLADE SUPPORT ASSY
4	1	B67-43001-83	D-PAD ASSEMBLY, SHORT
5	1	B67-43001-181	COVER PLATE
7	8	MS27039-1-10	SCREW
8	8	NAS1149D0316J	WASHER
9	12	NAS1149D0363J	WASHER

WF 14-01-09
#111110

RELEASED
2010-09-16
MB

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 10 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.07.28
REV.	DESCRIPTION			BY	DATE
DESIGN	R/W	DART AEROSPACE LTD			
DRAWN		HAWKESBURY, ONTARIO, CANADA			
CHECKED	PS	DRAWING NO.	B67-43001-23	REV. C	
MFG. APPR.		TITLE	LOWER BLADE SUPPORT AND COVER ASSY	SCALE	NTS
APPROVED	AND				
DE APPR.	N/A				
DATE	09.07.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

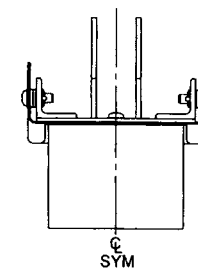
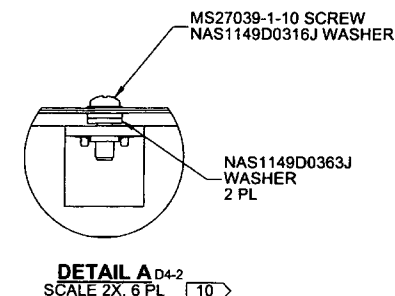
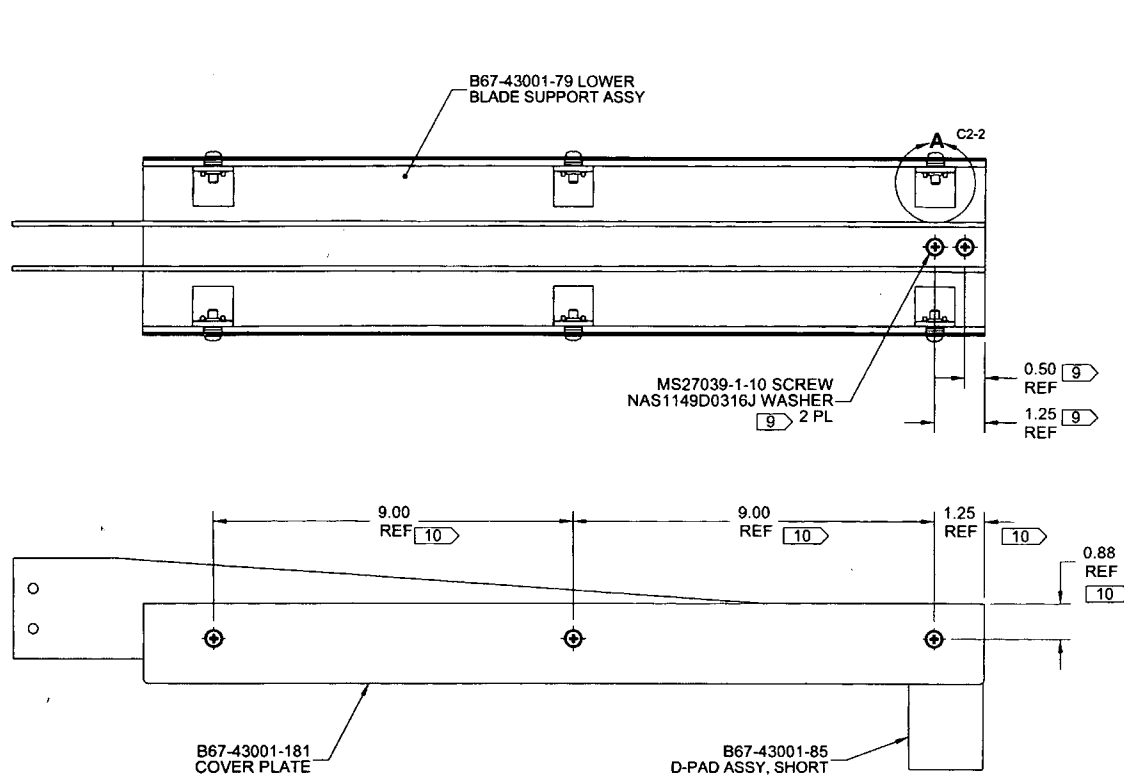
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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B67-43001-23 LOWER BLADE SUPPORT AND COVER ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.10 lbs
- 8) WELDING: PER DART QSI 004
- 9) MATCH DRILL $\varnothing 0.250$ THRU B67-43001-181 WITH HOLE PATTERN OF B67-43001-79
- 10) MATCH DRILL $\varnothing 0.250$ THRU B67-43001-181 WITH HOLES IN ANGLE BRACKETS ON B67-43001-79

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-23	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	LOWER BLADE SUPPORT AND COVER ASSY NTS	
DATE	09.07.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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RELEASED
2010-09-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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